

Ship Oct 15











Date: Friday, 9/21/2007 1:05:01 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GPS RECEIVER HOUSING
Job Number : 34800	
Estimate Number : 12517	
P.O. Number : N/A	Part Number : D3514047
This Issue : 9/21/2007 S.O. No. : N/A	Drawing Number : UNDER REVIEW D3514
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : N/A A 07/09/24
Previous Run : 33292	Material : N/A
Written By : _____	Due Date : 10/12/2007 Qty: 5 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est Rev:A New Issue 07-05-28 EC	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D35143	BOX TOP (TOP MOUNTED)
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) BOX TOP (BOTTOM MOUNTED) Batch: B 34821 <i>mf</i>		
2.0	D35147	BOX BOTTOM (TOP MOUNTED)
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) BOX BOTTOM (BOTTOM MOUNTED) Batch: B 34822 <i>mf</i>		
3.0	D35149	HOOD
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) HOOD Batch: 34823 <i>mf</i>		
4.0	D3524041	UPPER AND LOWER PLATE
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) UPPER AND LOWER PLATE Batch: 34824 <i>mf</i> 07-10-12		
5.0	MS20426AD313 4/07-09-24	RIVET
		
Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s) RIVET Batch: M1563 <i>mf</i>		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 34800

Part Number: D3514047

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

MS20426AD44

Rivet



Comment: Qty.: 11.0000 Each(s)/Unit Total: 55.0000 Each(s)

Rivet

Batch: M1021

PC

7.0

MS20426AD49

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

RIVET

Batch: M18136

PC

8.0

MS21072L06

ANCHOR NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

ANCHOR NUT

Batch: M101760

PC 7/8/11

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



PRC

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D3514

MF

07-10-12

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MF 07/10/04

11.0

POWDER COATING

POWDER COATING



1X

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

MF 07/10/25

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



1

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-10-26

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble trim as per dwg D3514

MF

07-10-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/10/12	5	split w/o	SK	07/10/12	1			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 07/10/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-23	9.0	The 03514-5 had 1 hole enlarged when a rivet was removed. RC: Human error.	<i>[Signature]</i>	Fill hole with weld per Q51004 : grind flush Transfer drill new hole Touch-up mess with alcohol. re-rivet : continue ASS'y	<i>[Signature]</i> 07-10-24 <i>[Signature]</i> 07-10-25	<i>[Signature]</i> 07-10-24	<i>[Signature]</i> 051012	<i>[Signature]</i> 12-10-23

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 34800

Part Number: D3514047

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D35261

RUBBER SEAL



mf

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

RUBBER SEAL

B 34825

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/25

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 07-10-26

17.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

07/10/26

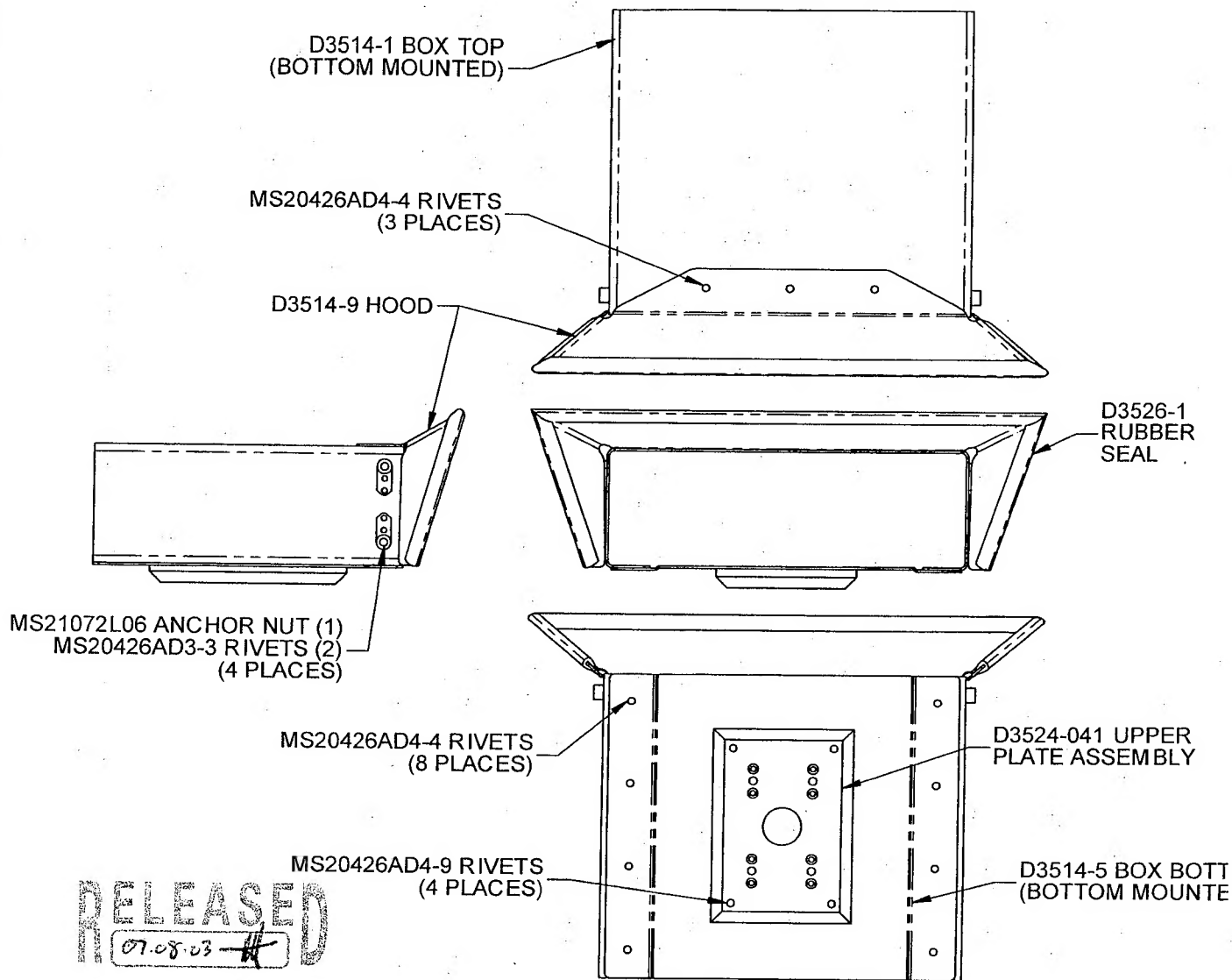
Job Completion



U 07.10.26



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED #	DRAWING NO. D3514
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	



D3514-045 BOTTOM MOUNTED HOUSING ASSEMBLY

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.